

Work Order ID 72805

Monday, August 15, 2011 10:43:36 AM



Page 1

Item ID: D3720-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 8/15/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 8/17/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/08/15 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3720 | Rev A |

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3720 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

6061 . 128

B11-8-15

(17)

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-8-15

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/15

(17)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 72805

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Item ID: D3720-1

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Revision ID:

Item Name: Step Spacer

Start Date: 8/15/2011 Start Qty: 8.00

Required Date: 8/17/2011 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130



Small Fab

Small Fab

Memo

Small Fab

C'sink as per dwg D3720

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

8/14/08/16 (17)

(47)
(7)

17 & 8/14/08/16

Work Order ID 72805

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Item ID: D3720-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 8/15/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 8/17/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

17X 8/11/08/16

170

Identify as per dwg & Stock Location: C-A

0.00



Packaging

Memo

0.00

Packaging

9/11/08/16 (17X)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/18

11-08-14 (17)

Picklist Print

Monday, August 15, 2011 10:43:33 AM

Page 1

Work Order ID: 72805



Parent Item: D3720-1



Parent Item Name: Step Spacer


Start Date: 8/15/2011

Required Date: 8/17/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev :A New Issue 08-01-11 EC verified by DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6S.125 | | Purchased | No | | | 100 | sf | 135.6514 | 0.085 | 0.715789 | 1.5 | | |
|  | | | | | | | | | | | | | |
| 6061-T6 .125 Sheet | | | | | | | | | | | | | |



1311-8-15

Location

Loc Qty

Loc Code

MAT021

135.6513684

113608

77.17

116700

3.98136842

118217

54.5

116700

(17)

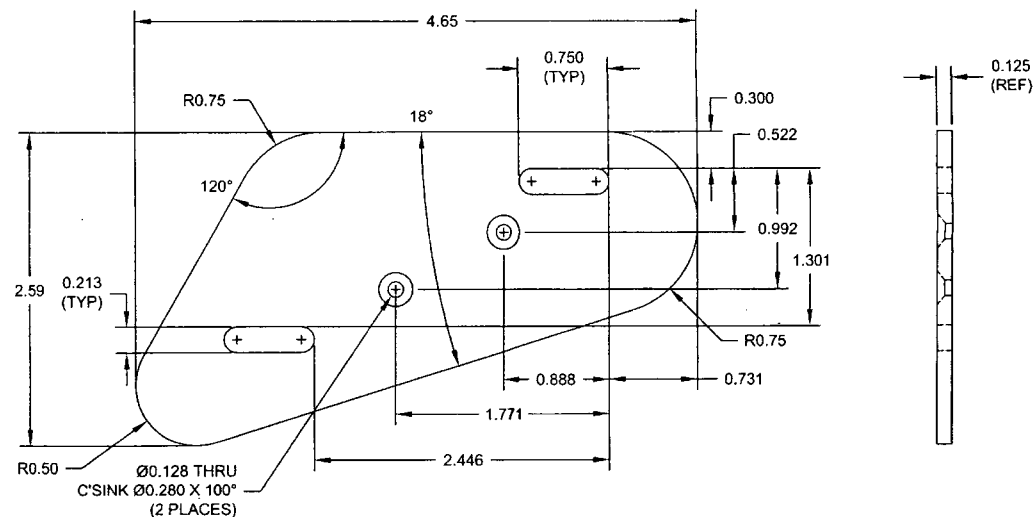
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

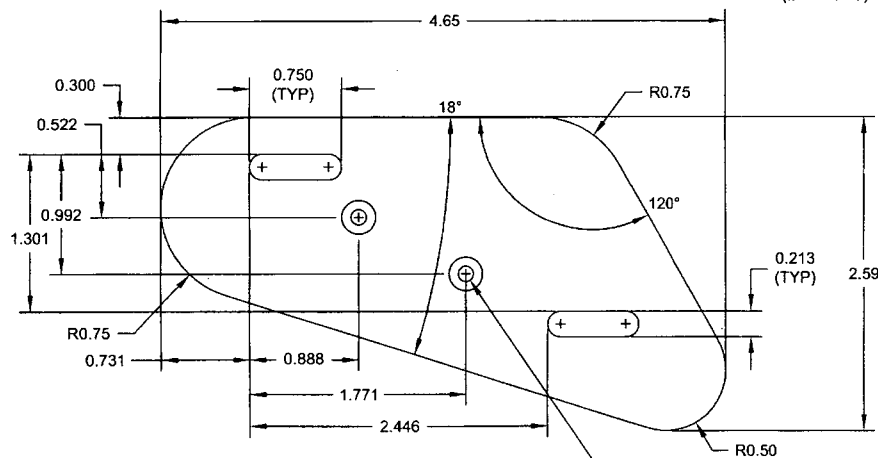
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries



D3720-1 STEP SPACER



D3720-2 STEP SPACER

NOTES:

- 1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.125 THICK (PER QQ-A-250/11 OR AMS 4025/4027) (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

CL11108115
W10.72805

RELEASED
06-01-10

| A | | NEW ISSUE | | PH | 07.12.27 |
|------------|----------|---|--|--------|--------------|
| REV. | | DESCRIPTION | | BY | DATE |
| DESIGN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | | |
| DRAWN | | | | | |
| CHECKED | | DRAWING NO. D3720 | | REV. A | |
| MFG. APPR. | | | | | SHEET 1 OF 1 |
| APPROVED | | TITLE | | | SCALE |
| DE APPR. | | STEP SPACER | | | 1:1 |
| DATE | 07.12.27 | COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | | | |

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 72805 |
| Description: Step Spacer | | Part Number: | D3720-1 |
| Inspection Dwg: D3720 Rev: A | | Page 1 of 1 | |



FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.128 | +0.005/-0.001 | .130 | ✓ | | ✓ RB02 | |
| 4.65 | +/-0.030 | 4.646 | ✓ | | ✓ | |
| 2.59 | +/-0.030 | 2.577 | ✓ | | ✓ | |
| 0.750 | +/-0.010 | .749 | ✓ | | ✓ | |
| 0.300 | +/-0.010 | .303 | ✓ | | ✓ | |
| 0.522 | +/-0.010 | .524 | ✓ | | ✓ | |
| 0.992 | +/-0.010 | .989 | ✓ | | ✓ | |
| 1.301 | +/-0.010 | 1.303 | ✓ | | ✓ | |
| 0.731 | +/-0.010 | .725 | ✓ | | ✓ | |
| 0.888 | +/-0.010 | .879 | ✓ | | ✓ | |
| 1.771 | +/-0.010 | 1.767 | ✓ | | ✓ | |
| 2.446 | +/-0.010 | 2.450 | ✓ | | ✓ | |
| 0.213 | +/-0.010 | .213 | ✓ | | ✓ | |
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|------------------------|-----------------------|----------------------------|-----|
| Measured by: RB | Audited by: J | Prototype Approval: | N/A |
| Date: 11-8-15 | Date: 11/02/15 | Date: | N/A |

| | | | | |
|------------|-------------|---------------|-------------------|---|
| Rev | Date | Change | Revised by | Approved |
| A | 08.02.29 | New Issue | KJ/DD |   |